



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

D4149-3
Job Sheet 186291



Part No: D4149-3
Part Name: Spacer
Job Qty: 20 ea

Status: New
Priority: Medium
Job Tracking No:
Created By: Marie Lajeunesse
Description:
Note: DWG REV C IPP REV A NEW ISSUE 10-06-24 JLM VERIFIED BY: DD IPP Rev: B 11.03.03 as per rev C DD
verf: JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Setup Run Hrs	Standard	Workcenter / Supplier Lead Time	Workcenter/Supplier
90	Start up Operation	30 Ea	11/30/18	0.00	0.00	0.00	Start Up Machining-2	Sign-off
100	Bandsaw	30 pcs	11/30/18	0.00	0.10	0.10	Bandsaw1	11/18-12-24
110	CNC Vertical Machining	30 pcs	11/30/18	0.12	13.10	0.12	HAA51-4	11/18-12-24
130	QC	30 pcs	11/30/18	0.00	0.00	0.00	QC8 Machining-2	11/18-12-24
170	Packaging	30 pcs	11/30/18	0.00	0.00	0.00	Packaging-3-2	11/18-12-24
180	QC21-SA	30 Ea	11/30/18	0.00	0.00	0.00	QC21	11/18-12-24

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.000X1.000	M303B1.000 X 1.000	10 ft (.33333333 ea)	90-Start up Operation	5136459

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.000X1.000	10	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.129inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Spacer	0.380inches ± 0.030	0.410 0.350	Diameter	
3	Spacer	0.630inches ± 0.030	0.660 0.600		
4	Spacer	1.588inches ± 0.010	1.598 1.578		
5	Spacer	2.430inches ± 0.030	2.460 2.400		
6	Spacer	0.630inches ± 0.030	0.660 0.600		
7	Spacer	1.587inches ± 0.010	1.597 1.577		

Container: 5140443

120112.20 11.03.51

Bien

16 p. in 157 BATH.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8	Spacer	0.750Inches $\pm$ 0.030	0.780 0.720	
9	Spacer	0.313Inches $\pm$ 0.010	0.323 0.303	
10	Spacer	0.380Inches $\pm$ 0.030	0.410 0.350	Radius
11	Spacer	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Spacer	0.750Inches $\pm$ 0.010	0.760 0.740	
13	Spacer	0.735Inches + 0.000 - 0.010	0.735 0.725	

Plex 11/14/18 7:14 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					